

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015972**Date Inspected:** 02-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD**ULTRASONIC INSPECTION****OBG SEGMENT 9EE-9DE**

ABF Request No: 08012010-2

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the deck panel splice weld between OBG segment 9EE and 9DE. Inspection was carried out on repair areas only. The weld designations are as follows.

OBE9A-008, 009 (OBG 9EE-9DE, D.P)

ULTRASONIC INSPECTION**OBG SEGMENT 9DE-9EE**

ABF Request No: 08012010-2

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the edge panel splice weld between OBG segment 9DE and 9EE on the (Cross beam side). Inspection was carried out on repair areas only. The weld designations are as follows.

OBE9A-006 (OBG 9DE-9EE, E.P-C.B side)

ULTRASONIC INSPECTION

OBG SEGMENT 9DE-9EE

ABF Request No: 08012010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the side panel splice weld between OBG segment 9DE and 9EE on the (Cross beam side). Inspection was carried out on repair areas only. The weld designations are as follows.

OBE9C-007, 006 (OBG 9DE-9EE, S.P-C.B side)

ULTRASONIC INSPECTION

OBG SEGMENT 9BW

ABF Request No: 08012010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back weld between deck panel and edge panel of OBG segment 9BW on the (counter weight side). Inspection was carried out on repair areas only. The weld designations are as follows.

CA059-002 (OBG 9BW- D.P to E.P, CW side @ 9AW)

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 9DE-9EE

ABF Request No: 08012010-1

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the side panel splice welds between OBG segment 9DE and 9EE on the (cross beam side). Inspection was carried out on repair areas only. The weld identification number were.

OBE9C-007, 006 (OBG 9DE-9EE, S.P-CB side)

During the magnetic particle testing ABF QA Inspector found six linear indications.

OBG SEGMENT 9DE-9EE

ABF Request No: 08012010-2

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the deck panel splice welds between OBG segment 9DE and 9EE. Inspection was carried out on repair areas only. The weld identification number were.

OBE9A-008, 009 (OBG 9DE-9EE, D.P)

No relevant indications were observed by this QA Inspector on this date.

OBG SEGMENT 9DE-9EE

ABF Request No: 08012010-2

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the edge panel splice welds between OBG segment 9DE and 9EE on the(cross beam side). Inspection was carried out on repair areas only. The weld identification number was.

OBE9A-006 (OBG 9DE-9EE, E.P-CB side)

No relevant indications were observed by this QA Inspector on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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